

41

5175543



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6101-007
Job Sheet 192801



Part No: D6101-007

Job Qty: 40 pcs

Part Name: Saddle Billet



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/2/19

Job Tracking No:

Due Date: 4/29/19

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	40 pcs	4/29/19	4/29/19	0.00	0.00	Purchasing - 1	AT 1904/25
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	40 pcs	4/29/19	4/29/19	0.00	0.00	Packaging 2 - 1 - B4B	AT 1904/25
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	

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					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120	QC 6	40 pcs	4/29/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	61
130	Packaging 3-1 - Stock - B4B	40 pcs	4/29/19	0.00 0.00	Packaging 3 - 1 - B4B	9-89
					Packaging 3 - 2 - B4B	07
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	DAS
					Packaging 3 - 34 - B4B	21
					Packaging 3 - 35 - B4B	9-89
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	40 pcs	4/29/19	0.00 0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-89

Part Op 100 - Issue P/O: _____ b) 7.750" x 8.250" x 2.50" thick d) Grain direction along 7.750" length
 Descriptions: 110 - (Receive & Inspect for Damage & Mat'l Certs), Ensure material certification is attached
 120 - (QC6- All purchased or subcontracted products), Ensure Material certification comply to Dwg D6101
 130 - (Identify as per dwg & Stock Location: _____), LOCATION: MAT041
 140 - (QC21- Final Inspection - Work Order Release)

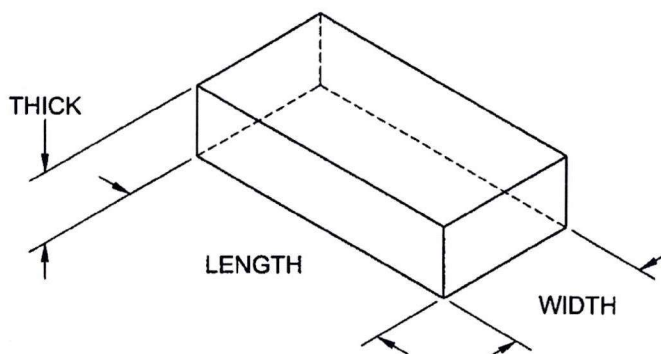
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007P	7075-T7351 8.25X7.75X2.5	40 pcs (1 ea)	100-Purchasing	5175539

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D6101-007P	40	0	0
Part Specifications				
Specifications could not be found.				

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SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

△ ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209 *AT*

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

△ B

RELEASED
09/07/15/WB

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043090



Supplier: MEC002-VU
Metaux Castle
P.O. Box 4090 Stn A
Toronto
ON
M5W OE9 Canada

PO No: PO043090

PO Date: 4/3/19

Due Date: 4/29/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED
APR 03 2019

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1 ✓ AT	192799	D6101-003P		7075-T7351 2X6.25X7.875 : Various STC's AS PER DWG D6101 REV. B SIZE: 7.875" X 6.250" X 2.00" THICK GRAIN DIRECTION ALONG 7.875" LENGHT MATERIAL: 7075- T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	4/29/19	20 pcs ✓	0 pcs 20x	20 pcs AT	\$38.82/pcs 1904/25	\$776.40
2 ✓ AT	192800	D6101-005P		7075-T7351 8.25X5.0X2.5 : Various STC's AS PER DWG.D6101 REV.B SIZE: 5.00" X 8.250" X 2.50" THICK GRAIN DIRECTION ALONG 5.00" LENGHT MATERIAL: 7075- T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	4/29/19	20 pcs ✓	0 pcs 20x	20 pcs 1904/25	\$40.54/pcs	\$810.80



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO043090



Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
3 ✓ AK	192801	D6101-007P		7075-T7351 8.25X7.75X2.5 : Various STC's AS PER DWG D6101 REV. B MATERIAL: 7075-T7351 (QQ-A-250/12) SIZE: 7.750" X 8.250" X 2.50" THICK GRAIN DIRECTION ALONG: 7.750" LENGTH TOLERANCE AS PER QUOTE +0.030/-0.000"	Firmed	-	4/29/19	40 pcs	0 pcs	40 pcs	\$61.72/pcs	\$2,468.80
4	192804	D6104-007P		17-4 SS Roundbar 4.50"Od AS PER DWG D6104 REV. B MATERIAL: 17-4 PH AS PER 17-4 (AMS 5643 OR AIS 630) MIN UTS = 170 KSI (38 HRC) TOLERANCE ON ALL DIMS IS +0.030/-0.0000	Firmed	-	4/29/19	10 pcs	0 pcs	10 pcs	\$68.53/pcs	\$685.30

Grand Total: \$4,741.30

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

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INTERORG TRANSFER
PACKING SLIP/
CERTIFICATE OF CONFORMANCE

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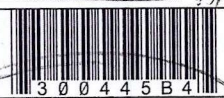
Shipment No:3876624

Ship From: A. M. CASTLE & CO. 14001 ORANGE AVENUE PARAMOUNT, CA 90723 USA		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 11-APR-19	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier ARCBEST		BOL No 3876624-2	

Shipment Details	Final Destination Branch - TOR
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Order No 5450764	Line No 3	Item No 752241.MO	Description 2.5000.PL.7075.T7351.ALUMINUM.USI.48.5000.144.5000 CUT RECTANGLE TO 8.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 7.75")) X 7.75 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 7.75")) - ALUMINUM PLATE SAW SPECIFICATIONS: AMS-QQ-A-250/12	
Purchase Order No 43090		Part Number YOUR ITEM NUMBER: D6101-007	Ordered Qty 40.00 PCS	Invoice Qty 40.00 PCS

Details	ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS
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Delivery No.	Mill/Source	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS)
122632135	KAISER ALUMINUM			32			529.0140
122632135	KAISER ALUMINUM			8			132.2535

INTERORG TRANSFER
PACKING SLIP/
CERTIFICATE OF CONFORMANCE

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These items are controlled by the U.S. Government and authorized for export only to the country of ultimate destination for use by the ultimate consignee or end-user(s) herein identified. They may not be resold, transferred, or otherwise disposed of, to any other country or to any person other than the authorized ultimate consignee or end-user(s), either in their original form or after being incorporated into other items, without first obtaining approval from the U.S. Government or as otherwise authorized by U.S. law and regulations.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:

Date:

Name:

[Handwritten Signature]



SHIP TO:

A M CASTLE & CO
14001 ORANGE AVE
P.O. BOX 1402
PARAMOUNT, CA 90723

KAISER ALUMINUM

Trentwood Works

PO Box 15108, Spokane Valley WA 99215-510

15000 E Euclid, Spokane Valley WA 99216

Phone: (800) 367-2586

SOLD TO:

AM CASTLE & CO- SOLD TO
1420 KENSINGTON RD
SUITE 220
OAK BROOK, IL 60523

CERTIFIED TEST REPORT

Serial Number

4551915

CUSTOMER PO NUMBER: 484033-1	WORK PACKAGE:	CUSTOMER PART NUMBER: 752241	SHIP RUN/LOAD: 104542/18	GOV'T CONTRACT NUMBER:
KAISER ORDER NO: 1273335-1	SHIP DATE: 18-FEB-2019	ALLOY: 7075	CLAD: BARE	TEMPER: T7351
WEIGHT SHIPPED: 7184 LB (3258.64 KG)	QUANTITY: 4 PCS EST.	TRUCK B/L #: 2079167	GAUGE: 2.5000 IN (63.5000 MM)	PRODUCT DESCRIPTION: KaiserSelect Plate
			DIAMETER/WIDTH: 48.500 IN (1231.9 MM)	LENGTH: 144.500 IN (3670.3 MM)

MHU 2302280: LOT 300445B4: 2 pieces;

MHU 2302281: LOT 300445B4: 2 pieces;

Certified Specifications

AMS 4078/RevK

ASTM B 209/Rev14

BSS 7055/RevB

DPS 4.713/RevAK

GSS16100/RevG/Amd1

PS 21211/RevP

AMS-QQ-A-250/12/RevA

ASTM B 594/Rev13

CMMP 025/RevV

EAC MS1011/RevE

MMS 159/RevT

AMS-STD-2154/RevC

BAC 5439/RevJ

CSTI 006/RevE

GAMPS 9101/RevB/AmdSCN1

PPS 20.04/Rev7

Test Code: 4297

Lot: 300445B4

Cast 756

Drop 54

Test Results

Ingot 3

Melted in USA

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	70.6 : 70.8 (487 : 488)	59.3 : 59.6 (409 : 411)	12.4 : 12.5

(ASTM E1004)

(EN 2004-1)

Conductivity %IACS :	41.9 Min	42.0 Max
(MS/M) :	24.3 Min	24.4 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.07	0.17	1.5	0.03	2.4	0.19	5.7	0.03	0.01	0.01	TOT 0.04



KAISER ALUMINUM

Trentwood Works

PO Box 15108, Spokane Valley WA 99215-5108
15000 E Euclid, Spokane Valley WA 99216
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4551915

ALLOY LIMITS

	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075												
MIN(wt%)	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX(wt%)	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

ORDER COMMENTS

AMC CA-15413B R 9

7055

TEST NOTES

Metal represented by this test report was 100% Type I
(immersion) ultrasonically tested from one side with 3mm
dead zones top and bottom and meets the Class A and Class B
requirements of all specifications referenced on this test
report. No surface marking of sonic indications is
performed.

CERTIFICATION

Kaiser Aluminum, Trentwood Works, is ISO 9001, AS9100, and ISO 14001 certified, and hereby certifies that all material shipped under this order:

- * has been inspected, tested, and found to be in conformance with the requirements of the specifications indicated herein.
 - * All test equipment and measuring devices are calibrated and certified in accordance applicable specifications. For material thicknesses outside specification limits, mechanical properties are as shown herein and chemical composition meets specification requirements. Reported elongation values have been measured as elongation at fracture.
 - * was melted in the United States of America or a qualifying country per DFARS 225.872-1(a), was manufactured in the United States of America, and meets the requirements of DFARS 252.225 for domestic content.
 - * has been thermally processed in compliance with AMS 2772, where applicable.
 - * is mercury free, within the limits of detection of ASTM E1215 (< 1 ppm).
 - * is in compliance with RoHS 2, European Union Directive 2011/65/EU.
 - * is in compliance with European Chemical Agency, ECHA, REACH regulations, (EC) No 1907/2006, and Kaiser regularly monitors these regulations for updates.
 - * is free of Conflict Minerals, as defined in Section 15.2 of the Dodd-Frank Act.
 - * is free of weld repair.
 - * meets the reporting requirements of EN10204, Type 3.1.
- Any warranty is limited to that shown on Kaiser Aluminum's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of the Kaiser Aluminum laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law.



Michael Peske, PT Lab Process Engineer

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6101-007
 DATE: 19/04/25

PO / BATCH NO.: P0043040/51755-13

MATERIAL CERT REC'D: Yes
 QUANTITY RECEIVED: 40x
 QUANTITY INSPECTED: 40x
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 2.500"
 THICKNESS RECEIVED: 2.500"
 SHEET SIZE ORDERED: —
 SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	☒ N	
CORRECT FINISH	☒ Y	N	
CORROSION	Y	☒ N	
CORRECT GRAIN DIRECTION	☒ Y	N	
CORRECT MATERIAL PER M-DRAWING	☒ Y	N	ASTM B209
CORRECT THICKNESS	☒ Y	N	
PHOTO REQUIRED	Y	☒ N	
CORRECT REF # TO LINK CERT	☒ Y	N	M: 30044584
CORRECT MATERIAL IDENTIFICATION	☒ Y	N	
CORRECT M# ON THE MATERIAL	☒ Y	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS 61</u>		SIGNED OFF BY: _____	
DATE: <u>9-89</u> <u>APR 25 2019</u>		DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in